DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-024035
Date Inspected: 20-May-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	N/A			**CWI Present:**	☐ Yes	☑ No	
Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 13AE, Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly

This QA Inspector performed Dimension Control Inspection on the Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly for Segment 13AE at the following locations along with ABF QA Mr. Wang at E3 locations. The Inspection was performed against the Notification # 09188 dated May 20, 2011.

Bearing Blocks are installed at PP 119 (-1500mm), Total 4 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119 (-1500mm), Total 4 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 to PP 119(-1500mm), Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119, Total 2 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119, Total 2 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 to PP 119(+1500mm), Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119 (+1500mm), Total 4 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119 (+1500mm), Total 4 locations at East side of the Floor Beam.

Dimension inspection was performed after passing the anchor rod at between the holes of Bearing Block to Bottom Plate and recorded the various measurements as following.

Gap between the Bearing Blocks to Floor Beam.

Mill to Bear (MTB) measured between the Stools to Bearing Block.

Mill to Bear (MTB) measured between the Stools to Bottom Plate.

Segment 13AE, Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly

This QA Inspector performed Dimension Control Inspection on the Bearing Block Assembly (for Anchor Bolt Seat) at OBG Trial Assembly for Segment 13AE at the following locations along with ABF QA Mr. Wang between work point E3 and E4 locations. The Inspection was performed against the Notification # 09188 dated May 20, 2011.

Bearing Blocks are installed at PP 119 (-1500mm), Total 6 locations at West side of the Floor Beam.

Bearing Blocks are installed at PP 119 (-1500mm), Total 2 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119(-1500mm) to PP 119, Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119(+1500mm) to PP 119, Total 4 locations at center of both the panel points.

Bearing Blocks are installed at PP 119 (+1500mm), Total 2 locations at East side of the Floor Beam.

Bearing Blocks are installed at PP 119 (+1500mm), Total 6 locations at West side of the Floor Beam.

Dimension inspection was performed after passing the anchor rod at between the holes of Bearing Block to Bottom Plate and recorded the various measurements as following.

Gap between the Bearing Blocks to Floor Beam.

Mill to Bear (MTB) measured between the Stools to Bearing Block.

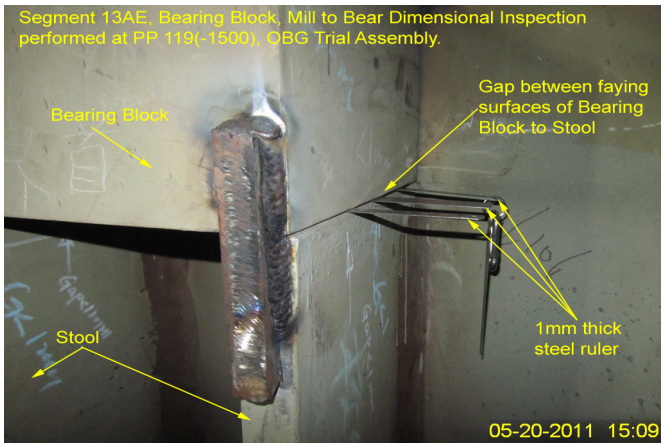
Mill to Bear (MTB) measured between the Stools to Bottom Plate.

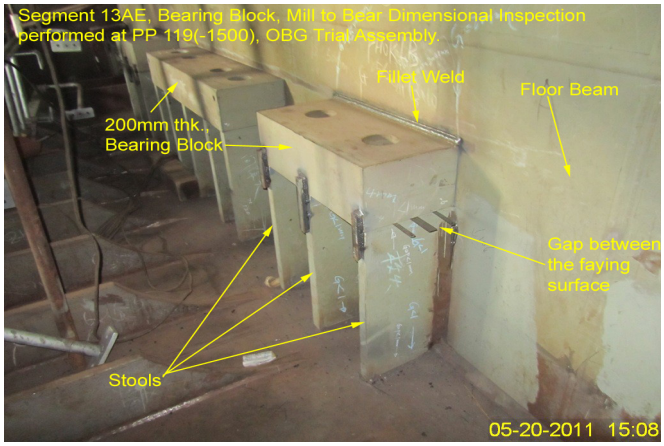
Note: During the process of Dimensional Inspection observed welder # 067148 performing fillet welding to the Bearing Block (200mm thick) to the Floor Beam at PP 119 (-1500) West side, observed 1mm gap between the vertical stool top face to the bearing block, it was confirmed by sliding the 1mm thick steel ruler inside the faying surface.

Informed the observation to the Caltrans Lead Inspector Mr. Rodney Patterson and Mr. Mark Miller and Mr. Wang of ABF. The welding was stopped after observing 1mm gap after fillet welding. Thus observed gap not in compliance with the contractual requirement.

Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for

your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer